

Date: Thursday, 05/02/2009 3:44:27 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206B BASKET BASE - UNDER REVIEW
Job Number	: 45545B		
Estimate Number	: 10681		
P.O. Number	:	Part Number	: D2330041
This Issue	: 05/02/2009 S.O. No. :	Drawing Number	: D2330 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: D
Previous Run	: 31456B	Material	:
Written By	:	Due Date	: 28/02/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>JD 09.02.06</u>		
Comment	: Est Rev.H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D31661	Basket Hoop
-----	--------	-------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
4	D3166-1	Hoop	B46475-23 B46628-21

Scrapped

JD 09.04.06

2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
-----	----------------	---------------------------



Comment: Qty.: 25.0000 f(s)/Unit Total : 25.0000 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: M119148

JD 09/04/06

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. JJ

Cut 4 D2235-1 From D3166-1 JJ/PD

2- Cut D2330-1-3-5-7-9 as per Dwg D2330 JJ

3-Drill hole in D2330-3 as per Dwg D2330 JJ

4-Debur JJ

JD 09/04/06

4.0	D22531	Lug
-----	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2253	Gusset	

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Thursday, 05/02/2009 3:44:27 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE - UNDER REVIEW

Job Number: 45545B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2012107

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2012-107 Clevis

6.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-3 Bushing

~~B40430~~ B46325

PD 09-04-06

7.0

D2581

Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2581 Mounting Chanel

8.0

D2254

Gussett



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2254 Lug

9.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 31.5000 sf(s)/Unit Total : 31.5000 sf(s)

Pick:

Qty Part Number Description Batch

30 sf M304EX0.75-16F Expanded Metal

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner JigDeburr as required

A/R SS ROD Batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 05/02/2009 3:44:27 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE - UNDER REVIEW

Job Number: 45545B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order Summary

January 6, 2010 10:09:01 AM

Page 1 of 1

Criteria : Work Order ID: 45545b Item ID: D2330-041RevG Product Family LARGE FAB  
 Work Order Start Dates 7/15/09 to 7/15/09 11:59:59 PM Work Order Required Dates 8/03/09 to 8/03/09  
 11:59:59 PM  
 All References  
 Work Order Status Costed

Work Order ID	45545B	Required Qty	1.0000	Status Code	Costed
Item ID	D2330-041RevG	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	Basket Base Assembly				
Current Acct Value	\$1,621.478	Sales Order ID			
Start Date	7/15/09	Required Date	8/03/09	Completed Date	12/10/09 11:21:08 AM

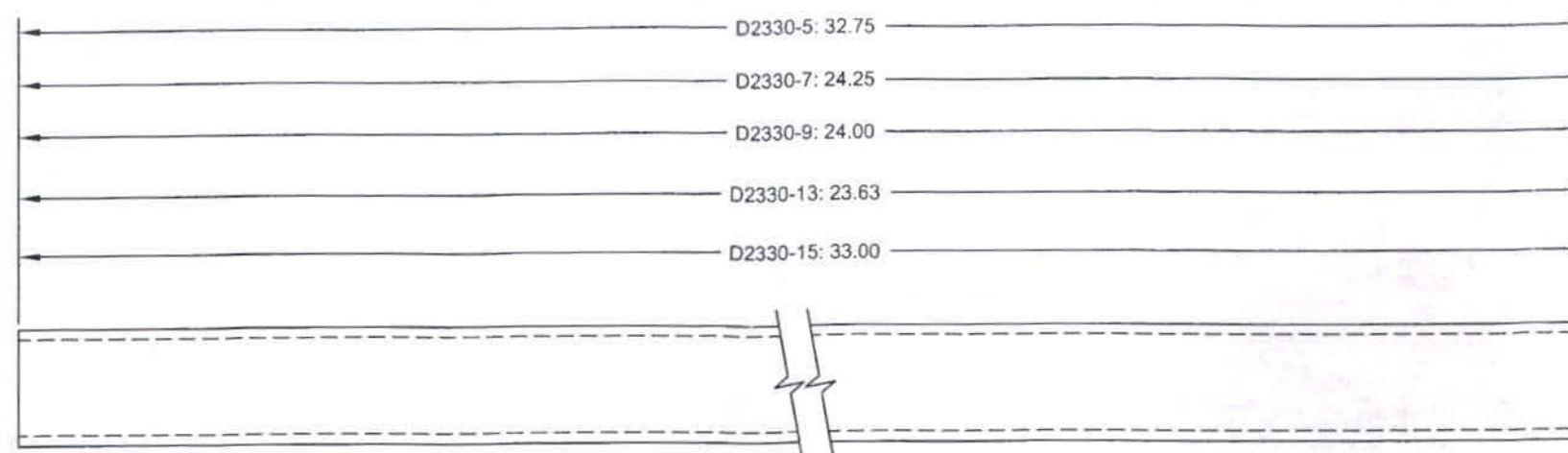
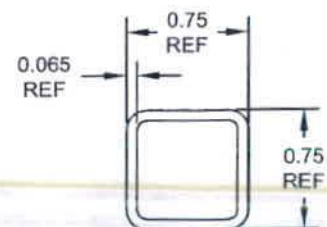
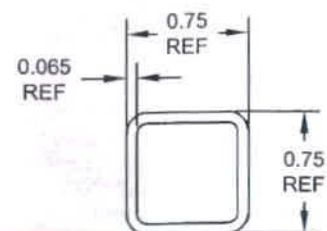
Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
Direct Costs	Total	Each	Each	Each	Each
Material	\$0.000	\$0.000	\$197.949	\$197.949	100.00%
Labor	\$36.090	\$0.000	\$0.000	\$0.000	0.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$72.920	\$0.000	\$0.000	\$0.000	0.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$109.010	\$0.000	\$197.949	\$197.949	

## Work Center

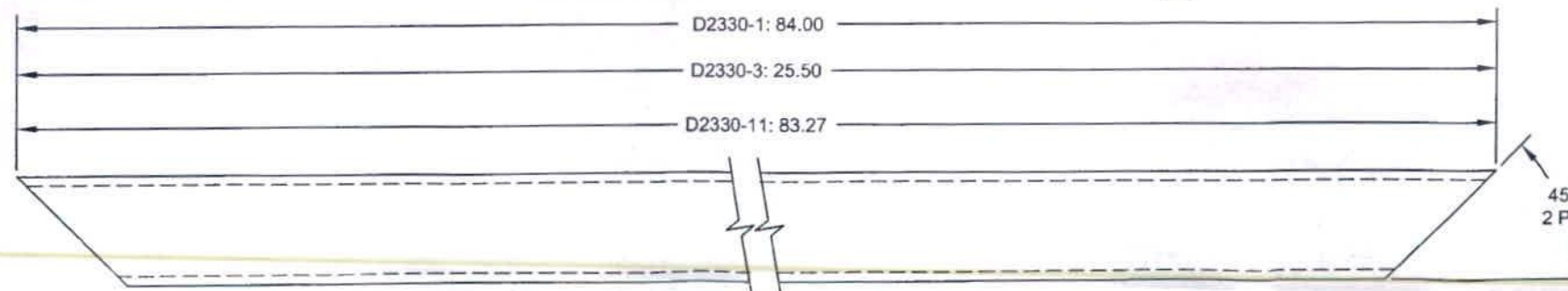
Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
ZWIP												
6/26/09												
N/A			0.00	0.00	-0.37	-0.37	1.00	\$0.000	-\$0.370	\$0.000	\$0.000	-\$0.37
N/A			0.00	0.00	36.46	36.46	1.00	\$0.000	\$36.460	\$72.920	\$0.000	\$109.38
Total:			0.00	0.00	36.09	36.09	2.00	\$0.000	\$36.090	\$72.920	\$0.000	\$109.01







D2330-5 FRAME  
D2330-7 FRAME  
D2330-9 FRAME  
D2330-11 FRAME  
D2330-13 FRAME  
D2330-15 FRAME



D2330-1 FRAME  
D2330-3 FRAME  
D2330-11 FRAME

**NOTES:**

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

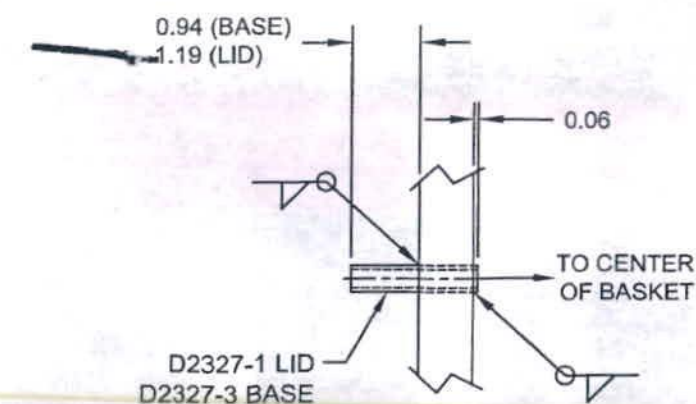
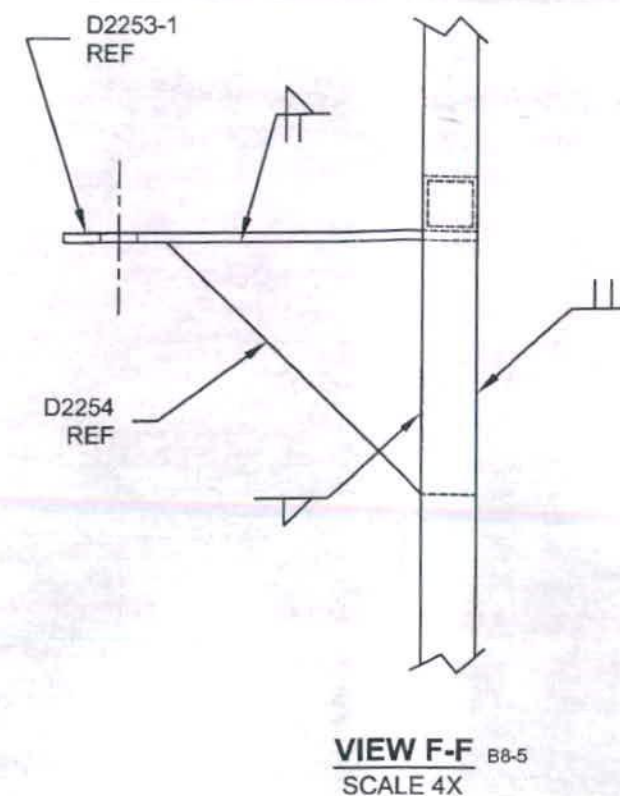
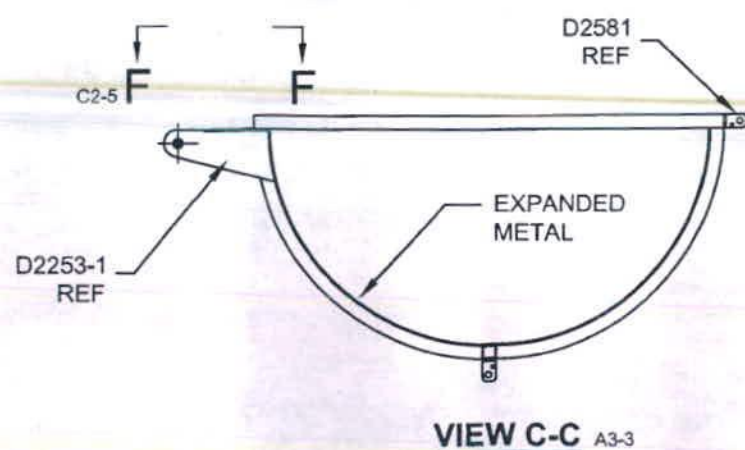
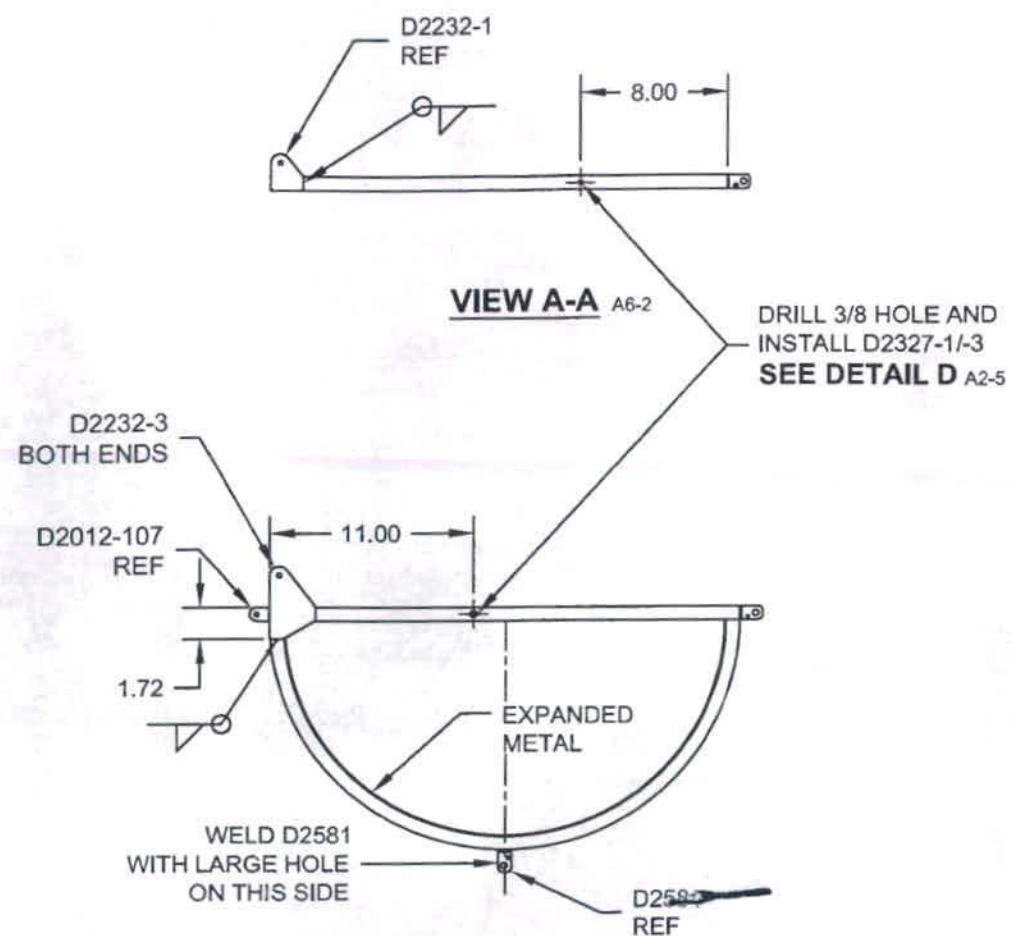
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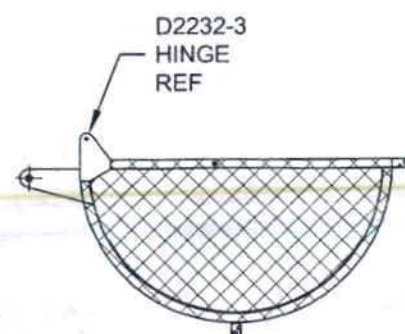
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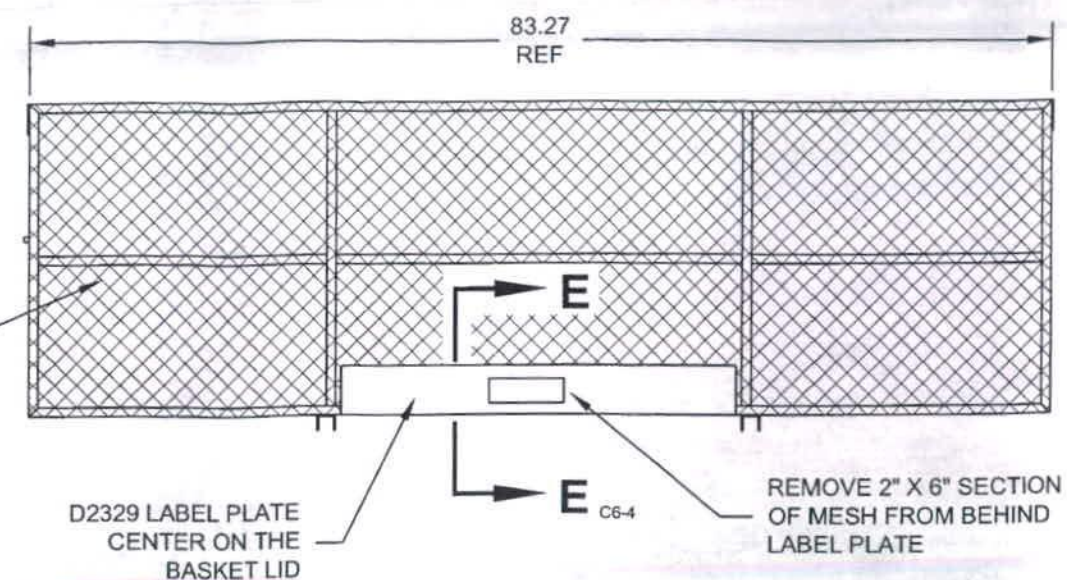
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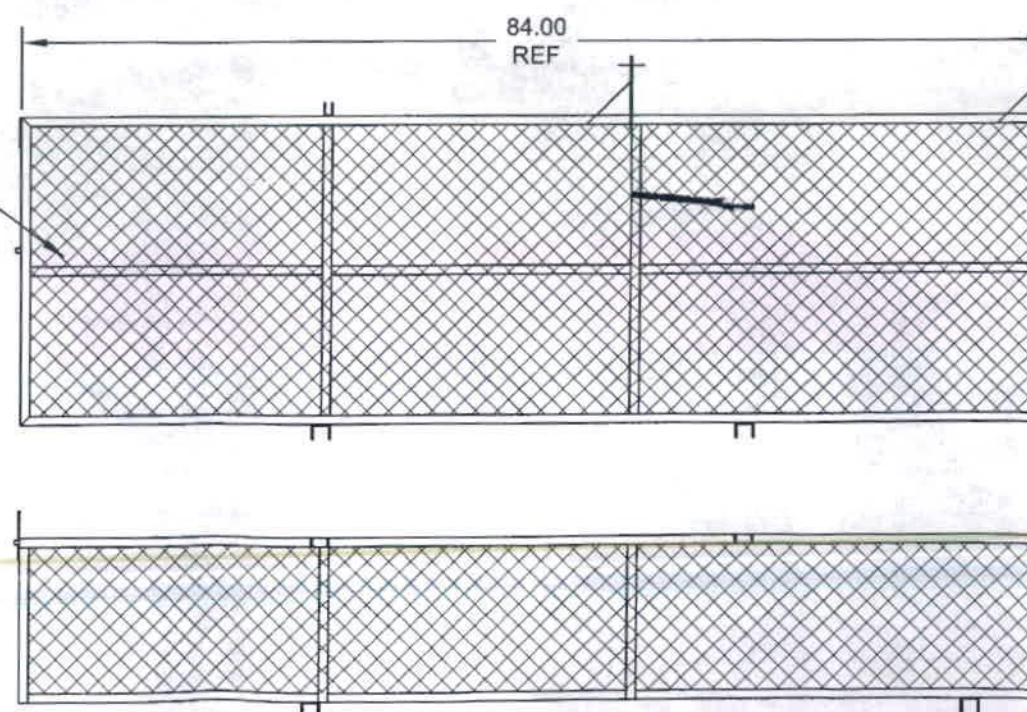
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- ASSEMBLY NOTES:**
- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A
  - 8) WELD PER DART QSI 004



## D2330-043 LID ASSEMBLY



**D2330-041 BASE ASSEMBLY**

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DRAWN	AJS		
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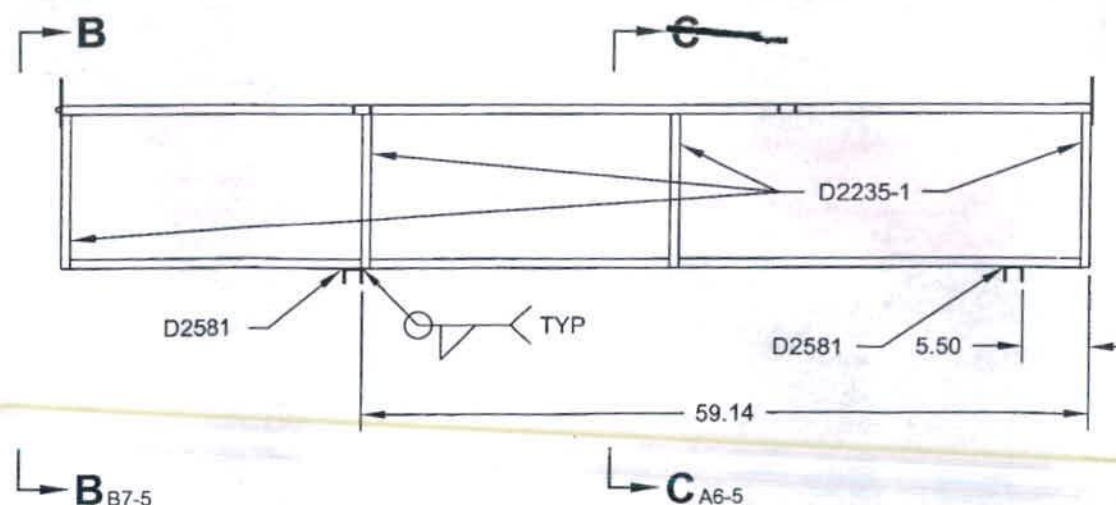
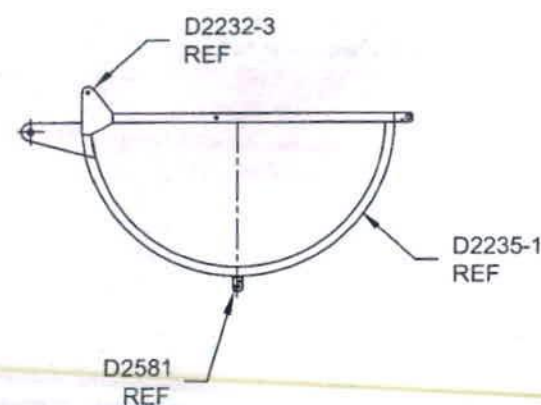
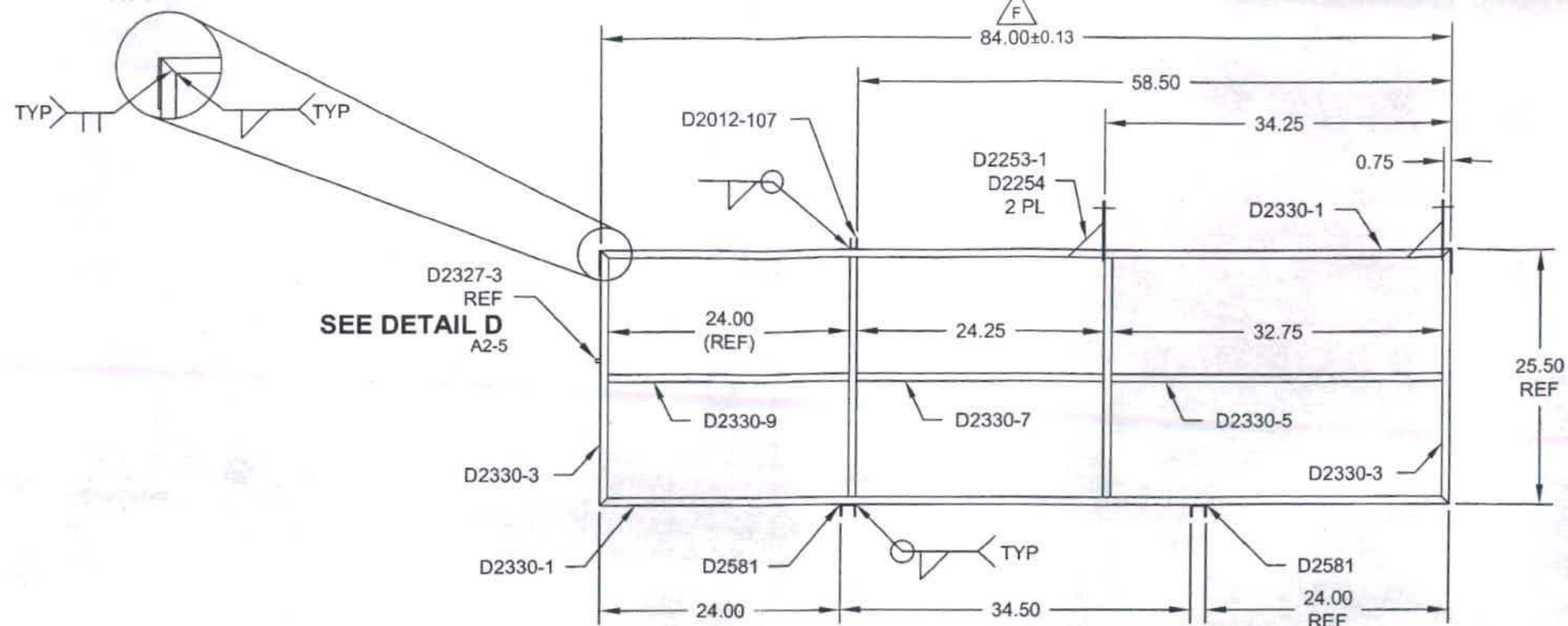
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WELD ALL JOINTS  
AS SHOWN



**BASE FRAME NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

**D2330-041 BASE FRAME ASSEMBLY**

DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
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8 7 6 5 4 3 2 1

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A

WELD ALL JOINTS  
AS SHOWN

TYP

TYP

F

83.27±0.13

D2330-3

D2330-11

D2330-9

D2330-15

D2330-3

25.50  
REF

D2327-1  
REF  
SEE DETAIL D  
A2-5

D2330-13

33.00

23.64

D2581

TYP

D2581

23.64

9

34.50

9

23.64

REF

9

D2232-1  
REF

A

A D6-5

D2330-043 LID FRAME

LID FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE

F

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8 7 6 5 4 3 2 1



1

1

1

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D2330-041	BASKET ASSEMBLY
	X	D2330-043	LID ASSEMBLY
1		D2012-107	CLEVIS
	2	D2232-1	HINGE
2		D2232-3	HINGE
4		D2235-1	RIB
2		D2253-1	LUG
2		D2254	GUSSET
	1	D2327-1	BUSHING
1		D2327-3	BUSHING
	1	D2329	LABEL PLATE
2		D2330-1	FRAME
2	2	D2330-3	FRAME
1		D2330-5	FRAME
1		D2330-7	FRAME
1	2	D2330-9	FRAME
	2	D2330-11	FRAME
	2	D2330-13	FRAME
	1	D2330-15	FRAME
4	2	D2581	MOUNTING CHANNEL



**NOTES:**

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

